



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

651.7510-B
Job Sheet 169815



Part No: 651.7510-B

Job Qty: 8 ea

Part Name: Saddle Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 12/22/17

Job Tracking No:

Due Date: 1/17/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Dart Aerospace Ltd - San Diego (CAPIC01)

3030 Enterprise Court, Suite A Vista, CA, 92081 USA ph:(760) 724-5300

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/15/18	0.00	0.00	Start Up Machining		FK 18-1-24
100	Bandsaw	6 pcs		1/15/18	0.00	0.01	Bandsaw1		FK 18-1-24
110	CNC Vertical Machining	6 pcs		1/17/18	0.15	32.81	HAAS 1		FK 18-1-24 / SBL 18/01/25
120	QC	6 pcs		1/17/18	0.00	0.00	QC2		FK 18-1-24 / SBL 18/01/25
130	QC	6 pcs		1/17/18	0.00	0.00	QC8		OK 18/01/26
180	Packaging	6 pcs		1/17/18	0.00	0.00	Packaging3		Sm 12
190	QC21-SA	6 Ea		1/17/18	0.00	0.00	QC21		JAN 26 2016

Part Op 100 - 42.350" long

Descriptions: 110 - 1-Machine per DWG 651.7500 DWG REV: B 2- deburr and break all sharp edge as per dwg

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S1-250X2-750	20	2	0	0
	1.750X3.000 5034218 x 23.25"				

Part Specifications

Specifications could not be found.

Plex 12/22/17 2:20 PM dart.poulin.mario

DAPOW 2207

DART
AEROSPACE
S034742

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle Adapter

PART NO: 651.7510
Original Serial #: S034742
Revision: B
Operation: Start up Operation
Change No:

01/24/18
Job No: 169815

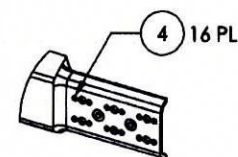
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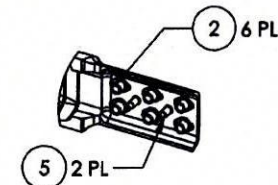
NOTES:

1. MARK IN ACCORDANCE WITH MPP-120 SECTION 4.4 LASER ENGRAVING
2. MATERIAL: 7075-T6 ALUMINUM PLATE PER AMS 4045 OR AMS 4044
3. FINISH: HARD ANODIZE PER MPP-172 SECTION 2.1
4. BREAK AND DEBURR ALL SHARP EDGES

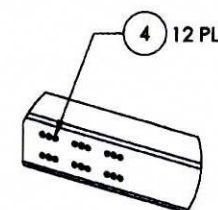
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
REV.	LAST PROTOTYPE RELEASE: P12		
HC	INITIAL RELEASE	10-15-17	P. BRAVO
A	DRAFT A3 OF 11/27/2017	11-15-17	P. BRAVO
B	INCORPORATED RCH 0884	11-28-17	P. BRAVO



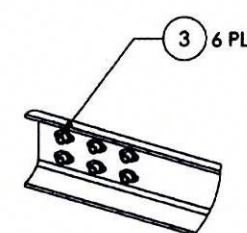
DETAIL A



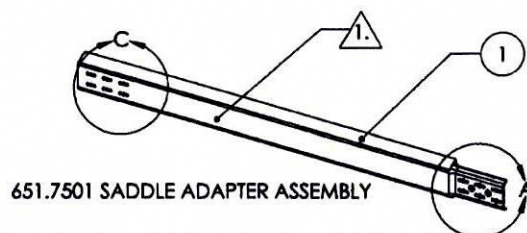
DETAIL B



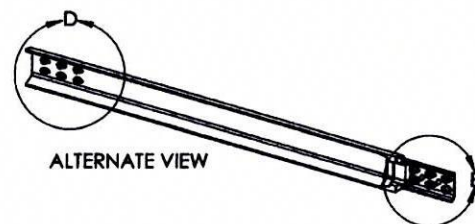
DETAIL C



DETAIL D



651.7501 SADDLE ADAPTER ASSEMBLY



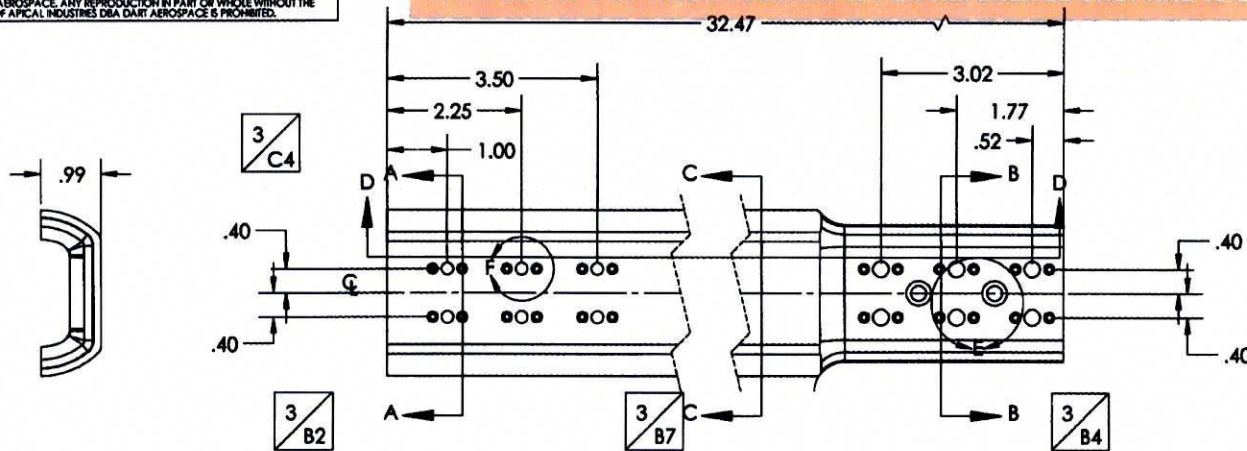
ALTERNATE VIEW

2	5	NAS1330S3-116L	NUT, BLIND RIVET		
24	4	CCR264CS-3-03	RIVET, COUNTERSUNK		
6	3	601.2361	NUT PLATE	MS21076-3N	
6	2	601.2730	NUT PLATE	MS21076-4N	
1	1	651.7510	SADDLE ADAPTER BLANK	△	△
X		651.7501	SADDLE ADAPTER ASSEMBLY		
7501	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

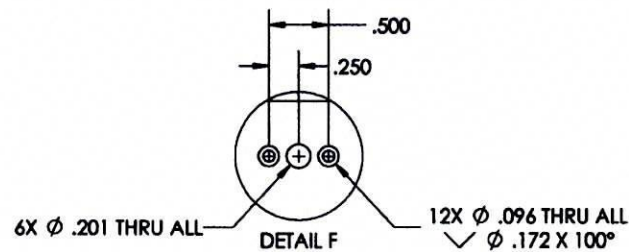
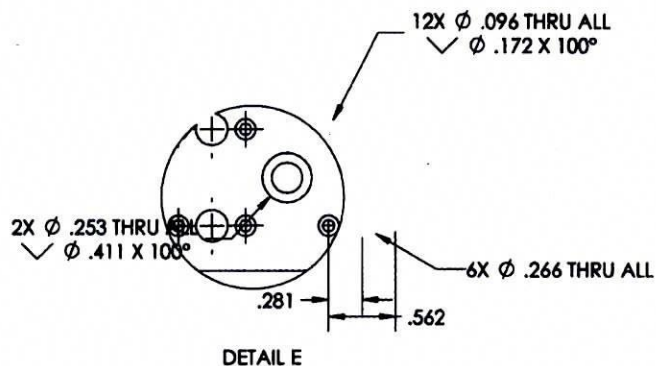
QTY		PARTS LIST			
NEXT ASSY (S)		ORIGINAL DATE	10-15-17	DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
651.5900		DRAWN BY	D. MARQUE		
		CHECKED	P. BRAVO		
		DRAWING APPROVAL	P. BRAVO		
		CONTRACT NO.		SKID EXT SADDLE ADAPTER	
		UNLESS OTHERWISE SPECIFIED		800 (CAGE CODE) DWG. NO.	
		TOLERANCES ARE:		B 07M26 651.7500 REV. B	
		2 PLACE DECIMALS ±.01		SCALE NONE SHEET 1 OF 3	
		3 PLACE DECIMALS ±.005			
		ANGLES ±.3°			

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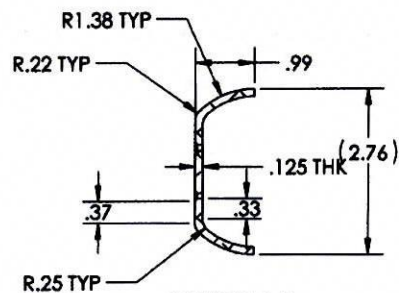
651.7510 SADDLE ADAPTER



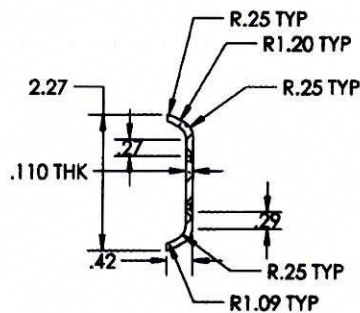
ORIGINAL DATE 10-01-17		10-01-17	
DRAWN BY D. MAURICE		P. BRAVO	
DRAWING APPROVAL P. BRAVO		10-01-17	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .01 3 PLACE DECIMALS .005 ANGLES ± .5°			
DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-5300		SKID EXT SADDLE ADAPTER	
SHEET 8	CAGE CODE 07M26	DWG. NO. 651.7500	REV. B
SCALE NONE		SHEET 2 OF 3	

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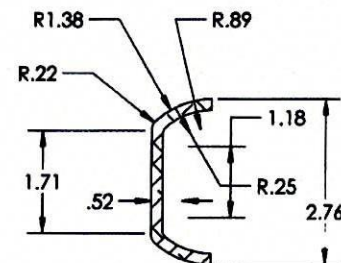
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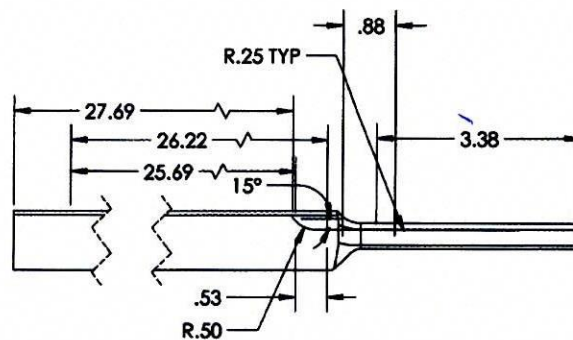
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D



ORIGINAL DATE REVISED DATE DRAWN BY D. MARCUS DRAWING APPROVAL P. BRAYO CONTRACT NO.	REV. 12 CHANGES P. BRAYO APICAL INDUSTRIES INC. DBA DART AEROSPACE	3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300
SKID EXT SADDLE ADAPTER		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .001 2 PLACE DECIMALS .005 ANGLES ± .5°	REV. 8 CAGE CODE 07M26 DWG. NO. 651.7500 SCALE NONE	REV. 8 SHEET 3 OF 3

DART AEROSPACE LTD		Work Order: 169815
Description: Skid Ext Saddle Adapter.		Part Number: 651-7501
Inspection Dwg: 651-7500 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.99	+/- .010	.993	✓		vern	SBL-01
32.47	+/- .010	32.471	✓		machine	measure class machine
3.50	+/- .010	3.496	✓		vern	
2.25	+/- .010	2.247	✓		vern	
1.00	+/- .010	.996	✓		vern	
.40	+/- .010	.40	✓		vern	
.40	+/- .010	.40	✓		vern	
3.02	+/- .010	3.023	✓		vern	
1.77	+/- .010	1.774	✓		vern	
.52	+/- .010	.523	✓		vern	
.40	+/- .010	.40	✓		vern	
.40	+/- .010	.40	✓		vern	
Ø .096	+ .004 / - .004	.096	✓		p.g.	
Ø .172 x 100°	+ .005 / - .001	.172 x 100°	✓		p.g.	
Ø .253	+ .006 / - .001	.253	✓		p.g.	
Ø .411 x 100°	+ .006 / - .001	.411 x 100°	✓		p.g.	
Ø .266	+ .006 / - .001	.266	✓		p.g.	
.562	+/- .005	.562	✓		vern	
.281	+/- .005	.281	✓		vern	
.500	+/- .005	.500	✓		vern	
.250	+/- .005	.250	✓		vern	
Ø .201	+ .005 / - .001	.201	✓		p.g.	
(.276)	+/- .010	.2766	✓		vern	
.125	+/- .005	.125	✓		mic.	118-120
2.27	+/- .010	2.265	✓		vern	
.110	+/- .005	.110	✓		mic.	118-120
1.71	+/- .010	1.72	✓		vern	
.52	+/- .010	.512	✓		mic.	118-120
3.38	+/- .010	3.380	✓		vern	
.88	+/- .010	.881	✓		vern	
27.69	+/- .010	27.690	✓		tape	
.53	+/- .010	.534	✓		vern	

Measured by: FR/SBL	Checked by: [Signature]	QC Inspector:
Date: 18-1-24/18-01-25	Date: 18/01/26	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Purchasing Receipts

PO No	Supplier	Line Item No	Rel No	Terms	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Received Quantity	Accounting Job No	Serial No	Status	Receive Date	Price/Unit	Aging Days	Past Due	Total	Supplier Name
PO038697	DIV001-VU	1	1	Net 30	M7075T6S1.750X3.000	7075-T6 Sheet 1.750" X 3.000" : MATERIAL: 7075-T6/T62 ALUMINUM SHEET AS PER QQ-A- 250/12 OR AMS-QQ-A- 250/12 OR AMS 4045 OR ASTM B209 receive ft				96	1/8/2018	48		S030258	Stock	1/8/2018	\$44.83 / ft	1		\$2,151.96	Diversified Industrial Products
Total:										96		48								\$2,151.96	

Plex 1/9/2018 8:25 AM Dart.Plouffe, Sonia

Status: Receiving

Part: **M7075T6S1.750X3**

Created: 1/9/18 8:24 AM DART.PLOUFFE.SON



Serial No: **S030258**



14 Connor Lane, Deer Park, NY 11729 Tel: 631.561.6200 Fax: 631.761.6201

Customer PO #	Order Date	SP
PO038697	12/20/17	AB

Sales Order Number	44870
Invoice Date	1/2/2018
Invoice Number	64915

Ship To:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

# Pkg.	1 BUNDLE
Weight	360 LBS

Ship Date	Shipped Via	Test Reports
1/2/2018	JOURNEY FRT	Y

Item #	Order Qty	U/M	Description	Qty Shipped	Bal. on Order
1	96	FT	7075-T6 ALUMINUM, QQ-A-250/12 OR ASTM B-209 1.75" X 3" X 48" MILL: KAISER LOT #: 704550B3 SHIPPING SCHEDULE: 12 PCS - ASAP 12 PCS - WEEK OF 01/12/18	48	48

8-18-01-9.

PACKING LIST
CERTIFICATE OF COMPLIANCE

We certify that the materials described above conform to the specifications stated.

Cathie Vail

Quality Control Manager



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038697**

Supplier: DIV001-VU
Diversified Industrial Products
14 Connor Lane
Deer Park, NY 11803 USA
Phone: 516 822 8300
Fax: 516 822 8332

PO No: PO038697

PO Date: 12/20/17

Due Date: 1/8/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
DEC 20 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	M7075T6S1.750X3.000		7075-T6 Sheet 1.750" X 3.000" : MATERIAL: 7075-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS 4045 OR ASTM B209 receive ft	Firmed	1/8/18	96 ft	0 ft	96 ft	\$44.8325/ft	\$4,303.92
										Recu 48 ft SP 18-01-9.
										Grand Total: \$4,303.92

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/20/17 1:50 PM dart.lavoie.chantal

SHIP TO:
DIVERSIFIED INDUSTRIAL PRODUCTS 14 CONNOR LANE DEER PARK, NY 11729
SOLD TO:
DIVERSIFIED INDUSTRIAL PRODUCTS 14 CONNOR LANE DEER PARK, NY 11729

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4478709

CUSTOMER PO NUMBER: 098007-3	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP RUNLOAD: 104048/16	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1242581-3	SHIP DATE: 20-SEP-2017	ALLOY: 7075	CLAD: BARE	TEMPER: T651
WEIGHT SHIPPED: 3766 LB	QUANTITY: 3 PCS EST.	TRUCK B/L N: 2069094	GAUGE: 1.7500 IN (44.4500 MM)	PRODUCT DESCRIPTION: KaiserSelect Plate
		DIAMETER/WIDTH: 48.500 IN (1231.9 MM)	LENGTH: 144.500 IN (3670.3 MM)	

MHU 2153028; LOT 704550B3; 3 pieces;

Certified Specifications

AMS 4045/RevL

AMS-QQ-A-250/ 2/RevA

ASTM B 209/Rev14

Test Code: 1312

Lot: 704550B3

Cast 534

Drop 30

Test Results

Ingot 1

Parent Lot: 245163B1

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper
T651

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
80.8 : 81.6
(557 : 563)

Yield KSI (MPA)
71.2 : 72.3
(491 : 499)

Elongation %
12.5 : 13.4

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	
Actual(wt%)	0.07	0.13	1.4	0.03	2.6	0.20	5.8	0.02	0.01	0.01	TOT	0.03

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

DIVERSIFIED INDUSTRIAL PRODUCTS CORP.
CERTIFY THIS A TRUE COPY OF THE
MILL TEST REPORT USED TO FILL YOUR
ORDER.

Company DART AEROSPACE LTD.

PO# PO038697

Our Inv. # 64915

Qty. 48 FT

Part #

QC Dept. Cathi Vail

Cathi Vail



Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4478709

CERTIFICATION

Kaiser Aluminum, Trentwood Works, is ISO 9001, AS9100, and ISO 14001 certified, and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein.
- * All test equipment and measuring devices are calibrated and certified in accordance applicable specifications. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. Reported elongation values have been measured as elongation at fracture.
- * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
- * has been thermally processed in compliance with AMS 2772, where applicable.
- * is mercury free, within the limits of detection of ASTM E1215 (<1ppm).
- * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
- * is in compliance with European Chemical Agency, ECHA, REACH regulations, (EC) No 1907/2006, and Kaiser regularly monitors these regulations for updates.
- * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
- * is free of weld repair.
- * meets the reporting requirements of EN10204, Type 3.1.

Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

JAMES HEMENWAY, TECHNICAL PROCESS MANAGER

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M70754651.750X3.000

PO / BATCH NO.: 038697/5030258

DATE: JAN 09 2018

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 48"
 QUANTITY INSPECTED: 48"
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 1.750
 THICKNESS RECEIVED: 1.750
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	AMS-QQ-A-250
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(X) N	Heat # 704550B3
CORRECT MATERIAL IDENTIFICATION	(X) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	WEBSTER
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>1-86</u> DATE: <u>JAN 09 2018</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: 6061-T6/T62 ALUMINUM SHEET

SPECIFICATION: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209

PART NUMBER: M6061T6S|XXX|
THK

WHERE "XXX" = SHEET THICKNESS (IN INCHES)

EG. 0.063" THICK SHEET = M6061T6S.063

PREFERRED SIZE: .XXX BY 4FT BY 8FT

RELEASED
2009-09-10

B	REFORMAT DWG. ADD B209 SPEC (2N D8-1).	CP	09 07 13
A	NEW ISSUE	DS	01 06 08
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. M6061T6S	REV. B
TITLE 6061-T6 SHEET SPEC	SHEET 1 OF 1
	SCALE NTS

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